

Work Order ID 158414***158414***

Page 1

Wednesday, March 22, 2017 1:24:07 PM

Item ID: 647.4114

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 3/23/2017 Start Qty: 5.00

5

Cust Item ID:

Required Date: 3/27/2017 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan:

DAS
21
9-89

Date: MAR 22 2017 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

647.4100

n/c

110

0.11

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: N/CProg Rev: N/C

2-Deburr if necessary

0.09

DAS
46
9-89

17/03/23

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.05

DAS
46
9-89

17/03/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			

Work Order ID 158414***158414***

Page 2

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Required Date: 3/27/2017 Req'd Qty: 5.00

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Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.10

Quality Control

DAS
38
9-89

MAR 23 2017

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

Outsource4

Memo

900.00

Outsource process - Anodize

Issue P/O to ATG :

35865

1- Black Anodize as per Dwg 647.4100

2- PRIME AS PER DWG, SEE NOTE #2

Certification of Conformity is required

5

APR 06 2017

DAS
13
9-89

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.10

Packaging

5x 8017-4-25.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 158414***158414***

Page 3

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Quality Control

Memo
2.5mil's Thickness

0.10

(5)

APR 25 2017

DAS
38

190

Identify as per dwg & Stock Location. CC112

0.00

190

Packaging

Packaging

Memo

0.05

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

DAS
5 6
9-89

APR 25 2017

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Quality Control

Memo

0.50

DAS
21
9-89

APR 26 2017

17/4/27

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : _____			

Picklist Print

Wednesday, March 22, 2017 1:24:14 PM

Page 1

Work Order ID: 158414

158414

Parent Item: 647.4114

647 4114

Parent Item Name: Shim

Start Date: 3/23/2017

Required Date: 3/27/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	63.7500	0.0328	0.172632			
									**				
											DAS 46 9-89	17/03/23	
M2024T3S 063													
2024-T3 .063 sheet													

Location

Loc Qty

Loc Code

MAT

8.2

m135512

8.2

MAT009

55.55

m134640

29.4

m135612

20.75

n136492

5.4

0.2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :					
Misidentified ☐	Past Due ☐						

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NL 04510

SHEET 1 OF 1

DWG NO. 647.4100

REV: N/C

PREPARED BY:

J. BECKER

DATE: 04/24/14

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: SHEETMETAL

APPROVED BY:

ENGR

MFG

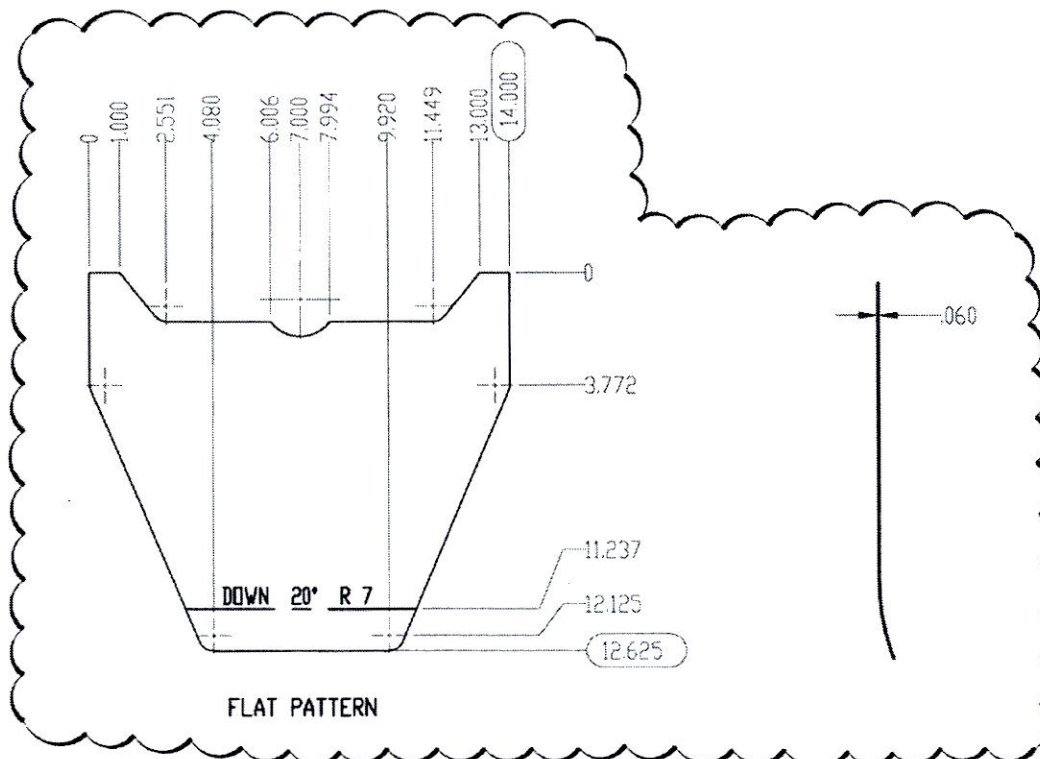
QC

EFF:

NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: MODIFIED DOUBLER.

**SHEET 1, ZONE C2 IS:**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158414 MJS
17-03-22

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOMCHANGE CATEGORY
☐ MAJOR ☒ MINORDER REVIEW REQUIRED
☐ YES ☒ NO

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02866				SHEET 1 OF 1	
	DWG NO. 647.4100	REV: N/C	PREPARED BY R. ROSANO	DATE: 05/05/10	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: SHEET METAL					
	APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>		EFF: <i>[Signature]</i> CURRENT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: CHANGED PRETREATMENT CALLOUT				

SHEET 1, ZONE A1 IS:

NOTES: UNLESS OTHERWISE SPECIFIED

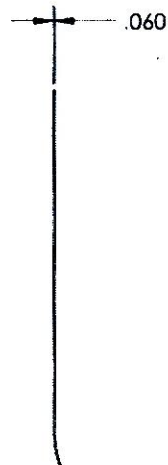
- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE II,
 CLASS 2, COLOR BLACK;
 PRETREAT PR-148 ADHESION PROMOTER
 PRIME IAW MIL-P-23377J TYPE I CLASS N

IS
- 3 DEBURR AND BREAK ALL SHARP EDGES
- 4 IDENTIFY IAW MPP-120

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO

NOTES: UNLESS OTHERWISE SPECIFIED

2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE II,
CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N



02866, 04510

		647.4116	SHIM	△	△
		647.4115	SHIM	△	△
		647.4114	SHIM	△	△
		647.4113	CLIP	△	△
		647.4112	CLIP	△	△
		647.4111	DOUBLER	△	△
		647.4110	DOUBLER	△	△
PIN#	PART #	DESCRIPTION	MATL	SPEC.	
QTY					
PART LIST					
APICAL INDUSTRIES					
2609 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-1100					
SHEETMETAL					
NEW ASSY IS 317.7200 DATE _____ DRAWN BY _____ CHECKED BY _____ DESIGNED BY _____ APPROVED BY _____ REVISIONS: 1. REVISED TO ADD 1/8" DIA. HOLE IN FRONT OF PART 2. REVISED TO ADD 1/8" DIA. HOLE IN BACK OF PART 3. REVISED TO ADD 1/8" DIA. HOLE IN TOP OF PART 4. REVISED TO ADD 1/8" DIA. HOLE IN BOTTOM OF PART  647.4100					

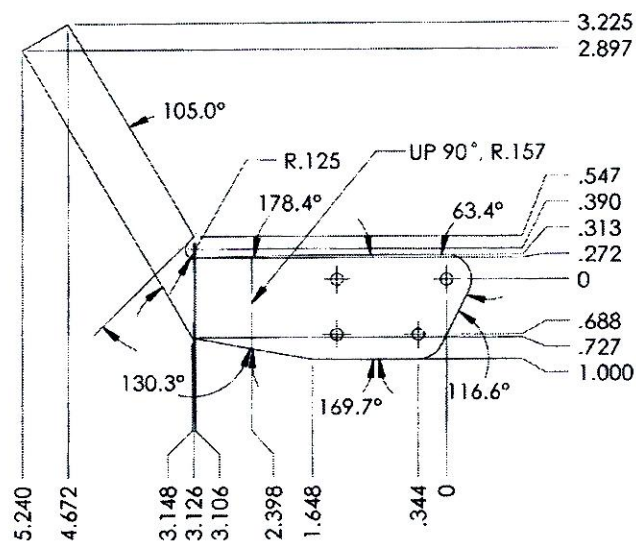
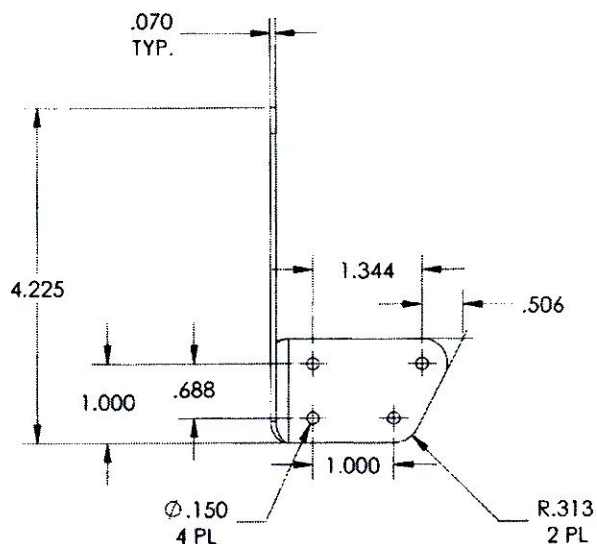
Abstract



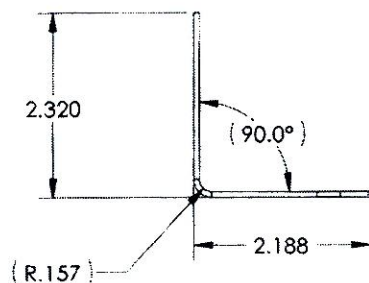
APICAL INDUSTRIES	
2628 IDEAL HEIGHT DR.	
CULLENDA, CA 95006-5612 (709) 294-5333	
SHEETMETAL	
8" 1/2" x 12" x 14"	5000
8" 1/2" x 12" x 14"	647 4100
8" 1/2" x 12" x 14"	SHEET 1000

THE INFORMATION CONTAINED ON THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. IT IS TO BE USED FOR THE PROJECT AND NOT FOR ANY OTHER PURPOSE. ANY REUSE OR MODIFICATION OF THIS DRAWING WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

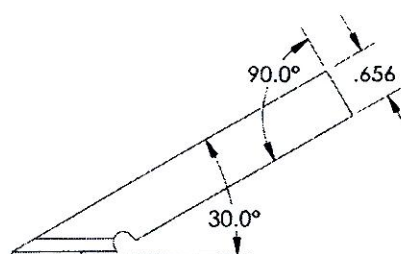
REV	DESCRIPTION	DATE	BY



FLAT PATTERN

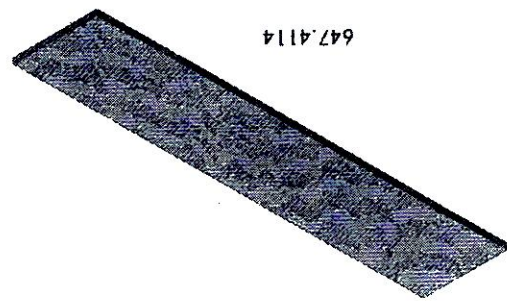
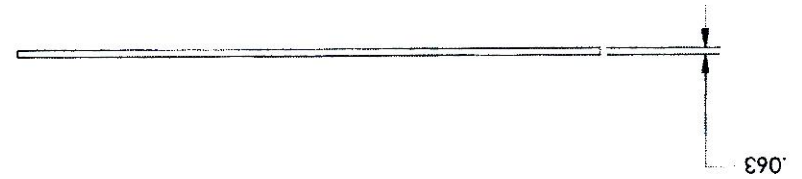
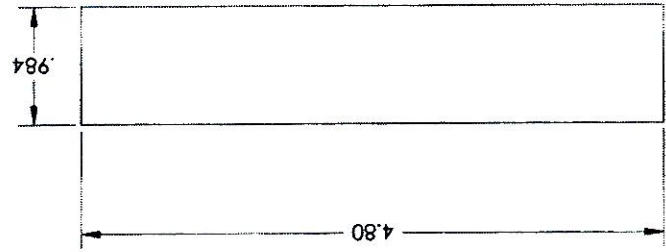


647.4113 SHOWN
647.4112 OPPOSITE



CUSTOMER: APICAL INDUSTRIES PROJECT: 647.4100 PART: 647.4113 DATE: 07/20/06 DRAWN: [blank] CHECKED: [blank] APPROVED: [blank]		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3511 (760) 724-5300	
SHEETMETAL 647.4100 SCALE: NONE		SHEET 3 OF 6	

APICAL INDUSTRIES		SHEETMETAL		SHEET	
2608 TEMPLE HEIGHT DR		OCEANSIDE, CA 92056-9512		(760) 724-5300	
SHEET NO.		647.4100		SHEET	
DATE		07/26		SHEET	
DRAWN BY		J. J. J.		SHEET	
CHECKED BY		J. J. J.		SHEET	
APPROVED BY		J. J. J.		SHEET	



1	2	3	4	5	6	7	8

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ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE IN INCHES
 ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED
 ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED

REV	DESCRIPTION	DATE	BY

A

B

C

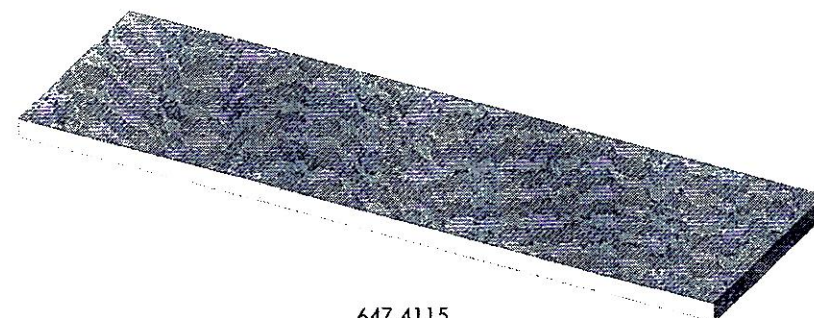
D

.090



3.25

.984

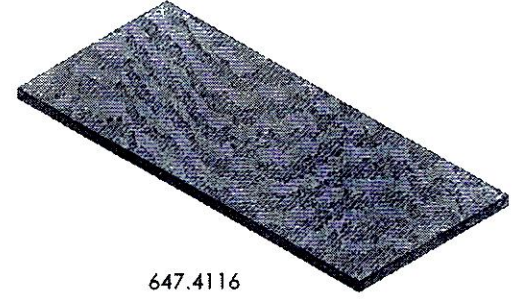
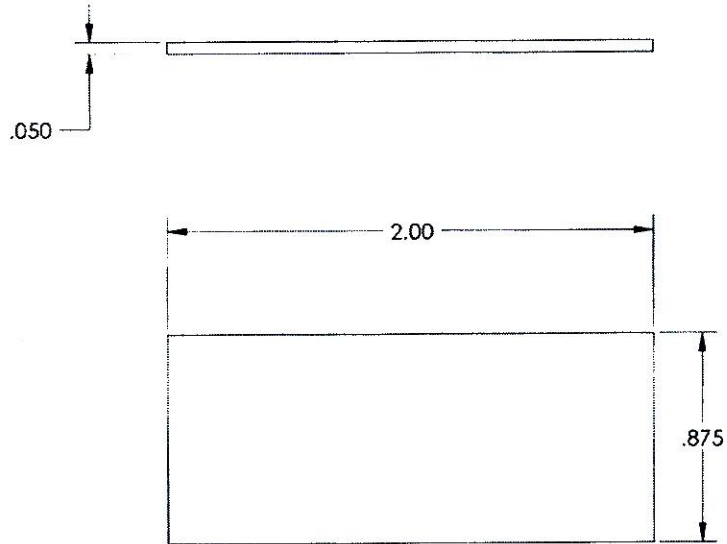


647.4115

APPROVED DATE DESIGNED BY CHECKED BY DRAWN BY SCALE	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5500
MATERIAL PART NUMBER QUANTITY UNIT	SHEETMETAL 647.4100 SCALE: NONE SHEET: 1 OF 1

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APICAL INDUSTRIES AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.

REV.	DESCRIPTION	DATE	BY



647.4116

APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300			
SHEETMETAL			
PART NO. 647.4116 QTY. 1000 DATE 01/01/00 BY J. B. B.	SIZE 12" X 12" X .005"	PART NO. 647.4100	PP. 16C
SHEET 6/16			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO35865

Purchase Order Date 4/6/2017
PO Print Date 4/20/2017

Page Number 3 of 6

VC-ATG001

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Buyer Chantal Lavoie

Contact Name
Vendor Phone

613-446-4544

Customer POID
Customer Tax #
Terms
Currency
FOB

10127-2607
Net 30
CAD
FCA - (Free Carrier)

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

VENDOR'S TRUCK

7 157798

650.9201 EYELET REV. A

4/24/2017

Yes

4/24/2017

10.00

\$6.60

\$66.00

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377 TYPE I CLASS N

Line Total:

\$66.00

8 158414

647.4114 SHIM REV. N/C

4/24/2017

Yes

4/24/2017

5.00

\$6.25

\$31

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377 TYPE I CLASS N

Line Total:

\$3

9 158416

647.4115 SHIM REV. N/C

4/24/2017

Yes

4/24/2017

5.00

\$6.25

\$2

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377 TYPE I CLASS N

Line Total:

\$

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

4/20/2017

SP174-25



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913226

Date: 24-Apr-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
5 ea	Part: 647.4114 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 20917	Rev: N/C <i>8017-4-25</i> Line: 8	
5 ea	Part: 647.4115 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 20918	Rev: N/C Line: 9	
DATE: <i>24/4/2017</i>			
CERTIFIED SIGNATURE: <i>[Signature]</i>			
RECEIVER SIGNATURE: _____			
Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
CERTIFICATE OF CONFORMANCE			
A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.			
MADE IN CANADA.			